

Date: Thursday, 04/09/2008 9:02:02 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR ASSEMBLY
 Job Number : 41797-2
 Estimate Number : 11403
 P.O. Number :
 This Issue : 04/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL / MED FAB
 Previous Run : 39871
 Written By :
 Checked & Approved By : JUD 08.9.04
 Comment : Est. C 05.10.14 Added step 14 KJ/EC
 Est Rev:D Revised Steps 06-11-20 JLM

Part Number : D3296041
 Drawing Number : D3296 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 11/09/2008 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch

1 D3296-1 Door Panel 39744

AS 08/09/04 (12)

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Door Panel

Pick:

Qty Part Number Description Batch

1 D3296-3 Door Panel 35233 x 2 39745 x 10

AS 08/09/04 (12)

3.0	D31617	Hinge 14.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Hinge 14"

Batch: B39891 x 10

AS 08/09/04 (12)

4.0	D31619	Hinge 17.0"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Hinge 17"

Batch: B39883

AS 08/09/04 (12)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Number: 41797

Part Number: D3296041

Number:



Seq. #: Machine Or Operation: Description:

5.0 MS20470AD44 Rivet, Universal Head



Comp wait take at 15



Comment: Qty.: 25.0000 Each(s)/Unit Total: 300.0000 Each(s)

Rivet, Universal Head

Batch:

MIG7823 x 157

all same Batch

AS 08/09/04 102

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

FF 08/09/10

(4)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/10 (24)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:40am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:10am

91 08-09-10

(X)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/09/10

(4)

10.0 D2137 Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Decal - No Step

Pick:

Qty

Part Number

Description

Batch

1

D2137

Decal

39139 x 7 MIG8012 x 5

AS 08/09/04 102

11.0 D2419 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Handle

Pick:

Qty

Part Number

Description

Batch

1

D2419

Handle

39881 x 7

AS 08/09/04 102

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Order Number: 41797

Part Number: D3296041

Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2462

Seal



Comment: Qty.: 0.3333 f(s)/Unit Total: 3.9996 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 4.00" LONG

37747

JS 08/09/04 (12)

13.0

D2462

Seal



Comment: Qty.: 0.4420 f(s)/Unit Total: 5.3040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 5.30" LONG

37747

JS 08/09/04 (13)

14.0

D2462

Seal



Comment: Qty.: 2.0420 f(s)/Unit Total: 24.5040 f(s)

Qty Part Number Description Batch

1 D2462 Seal

CUT ONE PIECE 24.50" LONG

37747

JS 08/09/04 (14)

15.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

39012*

JS 08/09/04 (15)

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

M6005

JS 08/09/04 (16)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 41797

Part Number: D3296041

Job Number:



Seq. #:	Machine Or Operation:	Description :
17.0	MS20470AD46	Rivet, Universal Head
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch 1 MS20470AD4-6 Rivet <u>MC8377</u> <u>JS</u> <u>08/09/10</u> <u>102</u>		
18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3296 <u>FF</u> <u>08/09/10</u> <u>(4)</u>		
19.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO CURRENT STEP <u>S. Solorio</u> <u>(4)</u>		
20.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>SH</u> <u>slalo</u> <u>SC</u>		
21.0	QC21	FINAL INSPECTION/W/O RELEASE
 		
Comment: FINAL INSPECTION/W/O RELEASE <u>08/09/11</u>		

Job Completion

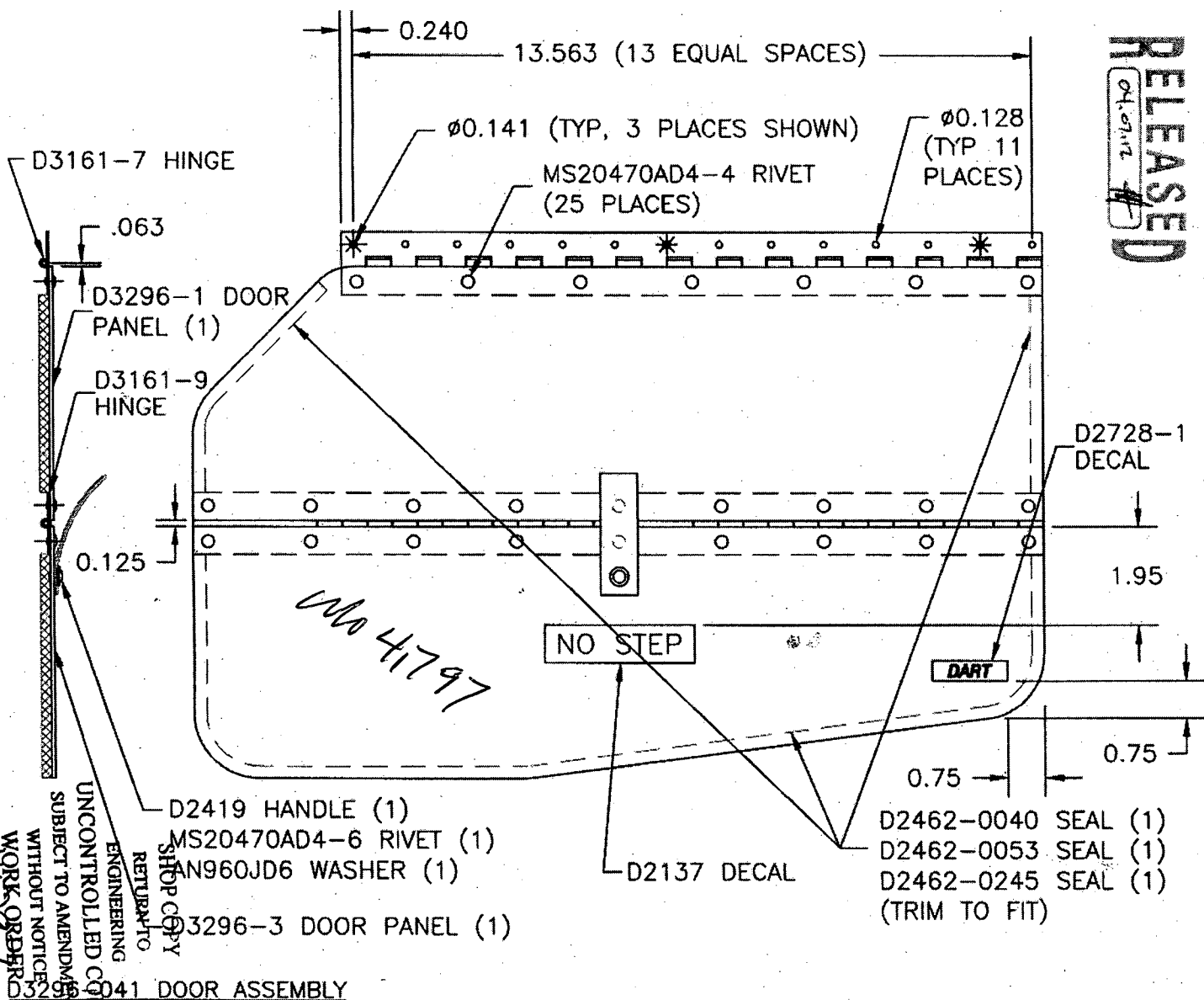
U 08/09/11

DART



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 04.06.28	DRAWING NO. D3296	REV. A
	TITLE DOOR ASSEMBLY	1 OF 2
A	04.06.28	SCALE 1:3
	NEW ISSUE	



- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
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